

Date: Thursday, 14/05/2009 11:11:37 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
Job Number : 47960 -1
Estimate Number : 12973
P.O. Number :
This Issue : 14/05/2009 S.O. No. :
Prsht Rev. : NC Part Number : D36461
First Issue : 11 Type : SMALL /MED FAB Drawing Number : D3646 U/R
Previous Run : 47718 Drawing Revision : A
Written By : Due Date : 21/05/2009 Qty: 2 Um: 10 Each
Checked & Approved By : MF 09-05-14
Comment : Est Rev. A new issue 07.07.25 EC verified by:JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.0790 f(s)/Unit Total : 20.7900 f(s) 4.158
Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: 17111704

FF 09-05-14

(2)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8958

FF 09-05-14

(2)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

FF 09-05-14

(2)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/14

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

7:40
320°

Cmo

09/05/15

(X2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47960

Part Number: D36461

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

8:10

UMD 09/05/15

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BP 04-05-15 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 229

SS 09/05/15 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19

Job Completion



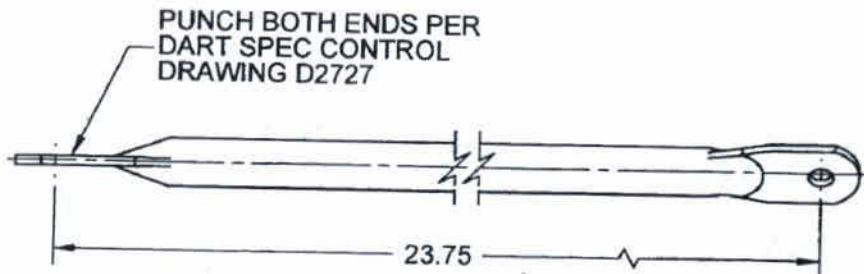
MF 09-05-15



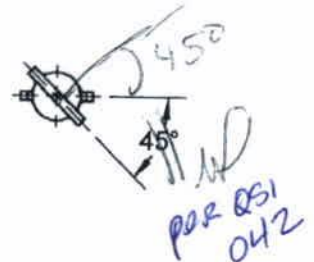
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED

07.07.06 *[Signature]*



24.55 Tot. length
24 9/16



#47960

D3646-1 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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